

Date: Tuesday, 30/09/2008 8:54:28 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 42347		
Estimate Number	: 11169		
P.O. Number	:	Part Number	: D32831
This Issue	: 30/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3283 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 39163	Drawing Revision	: E
Written By	:	Material	:
Checked & Approved By	: <u>TUD 08.9.30</u>	Due Date	: 15/10/2008
Comment	: Est A 04.09.28 New issue KJ/JLM Est Rev:B Now on Waterjet 07-05-28 JLM Est Rev:C As per Rev E 07-09-09 JLM Verified By:EC		

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.2479 sf(s)/Unit Total : 7.4372 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Identify for D3283-1
 Batch: 108579 AB 8-9-30

(36)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3283
 Dwg Rev: E AB 8-9-30
 Prog Rev: E
 2-Deburr if necessary AB 8-9-30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/09/30 (436) counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

u/a 8/9/30

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

One at a time #22
8/10/30 (36x)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

HH 08-10-02 (36x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h 08/10/02 (36x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 17

8/10/2

SP

(36x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/03

Job Completion



u 08/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

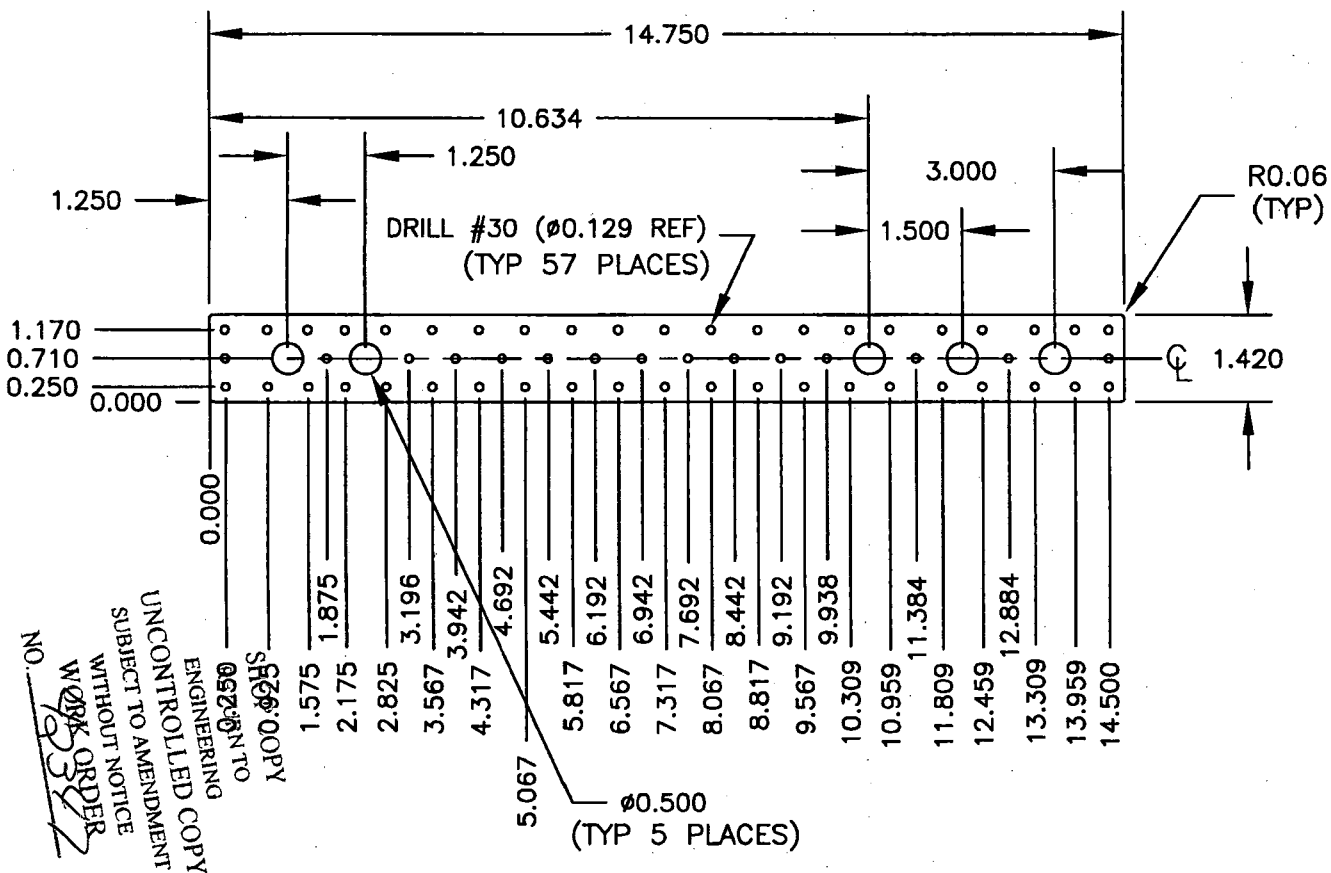
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
07-08-2014
PER ECN 969

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
DATE		D3283	REV. E
07.06.01		TITLE	SHEET 1 OF 2
		DOUBLER	SCALE
			1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	



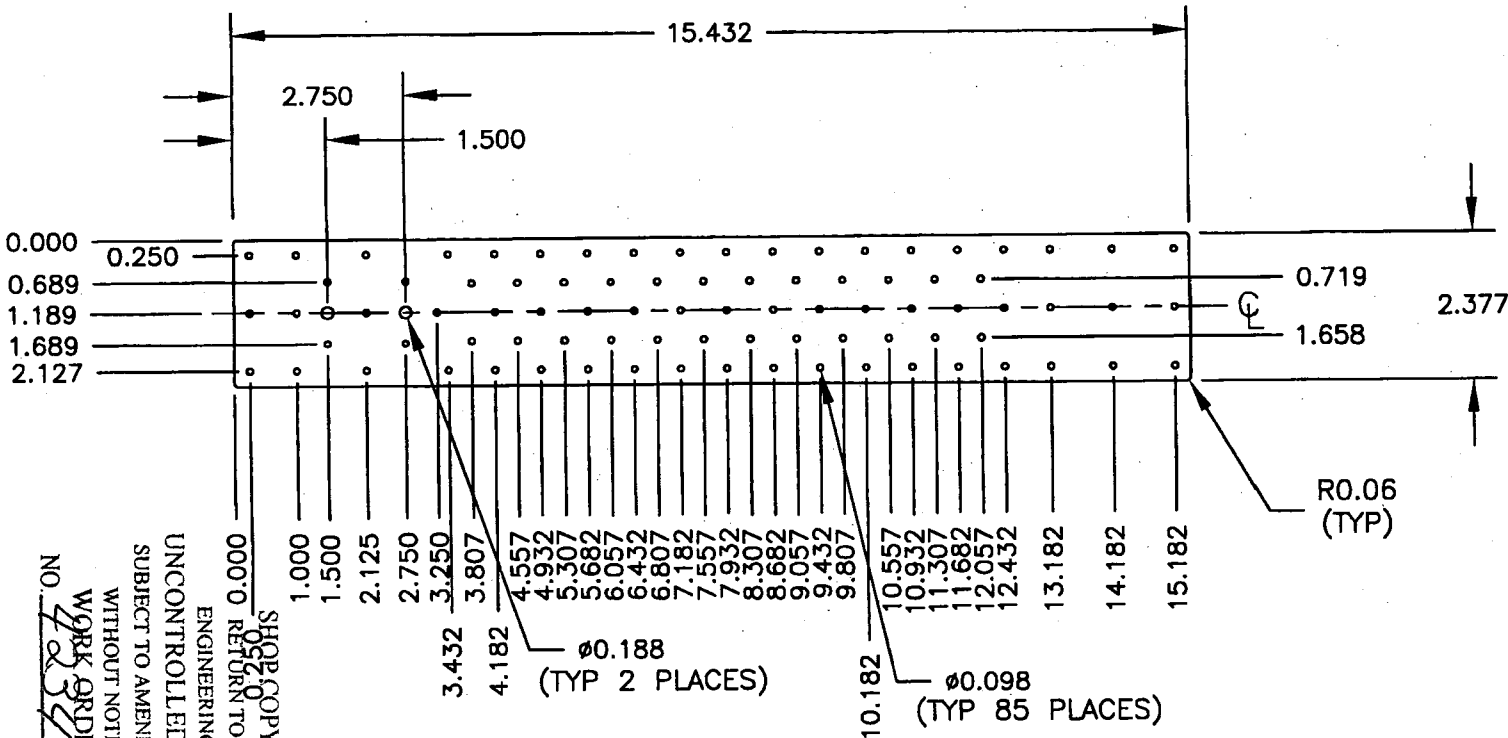
D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D3283	SHEET 2 OF 2
07.06.01		DOUBLE	SCALE
			1:3

RELEASED
07.08.94
PER ECN 959



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED